

Work Order ID 79212

Monday, January 23, 2012 3:26:26 PM

79212

Page 1

Item ID: D206-667-201

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Aft

Start Date: 1/23/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 1.00

1

Customer:

Reference: REWORK

DART		TEL: 1-613-632-3336	
TRANSPORT CANADA APPROVAL # 09-99		FAX: 1-613-632-4443	
P/N	D206-667-201	CHG	CHG002
DESC	Crosstube Aft High	SIC	SH01-5
LOT	B30442	SIC	SR01304NY
MODEL	Bell 206A/B	SIC	
MADE IN CANADA			

Approvals: Process Plan: *mf*

Date: *12-01-23* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

MADE IN CANADA

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-667-241	Rev C (DEO)
DSI 9471	Rev A

290

0.00

290

Crosstubes

Crosstubes

Memo

0.00

PULL FROM STOCK D206-667-201 B 30442 *CHG002*

1) REMOVE SUPPORTS AND REWORK TO LATEST DRAWING
(*SUPPORTS ARE NOW INSTALLED USING PROSEAL INSTEAD OF
MAGNABOND)

2) REMOVE ABRASION STRIPS AND CLAMPS AND DISCARD

300

QC5- Inspect part completeness to step on W/O

0.00

300

QC

Quality Control

Memo

0.00

AS 12 - 1 - 26

12 . 01 . 26 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79212

Monday, January 23, 2012 3:26:26 PM

79212

Page 2

Item ID: D206-667-201

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Aft

Start Date: 1/23/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 1.00

1

Customer:

Reference: REWORK

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

310

Powdercoat

Powder Coating

Memo

SCUFF AND REPAINT TUBE IF NECESSARY

0.00

N/A

320

320

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

N/A

0.00

h

330

330

Crosstubes

Crosstubes

Memo

RE-ASSEMBLE TUBE USING REWORKED SUPPORTS

0.00

0.00

ADD D3595-063-395 RUBBER CUSHION X 4

ADD MS210920-20 X 4

AS 12 - 1 - 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 79212

Monday, January 23, 2012 3:26:26 PM

79212

Page 3

Item ID: D206-667-201

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Aft

Stop

NS2

Start Date: 1/23/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 1.00

1

Customer:

Reference: REWORK

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

340

QC5- Inspect part completeness to step on W/O

0.00

340

QC

Memo

0.00

Quality Control

Handwritten: 12 - 01 - 31 (1)

360

Identify as per dwg & Stock Location: _____

0.00

350

Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

Handwritten: NEW PAPERWORK + LABELS - 12-1-31 CH 6004

360

QC4- 100% Inspect kits for completeness

0.00

360

QC

Memo

0.00

Quality Control

Handwritten: 5/2/02/01

Handwritten: CH 6004

Handwritten: 12-02-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, January 23, 2012 3:26:25 PM

Page 1

Work Order ID: 79212

Parent Item: D206-667-201

Parent Item Name: Crosstube Aft

Start Date: 1/23/2012

Required Date: 1/27/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
615 DD VERF:EC

IPP REV:B 11.08.08 PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3595-063-395 RUBBER CUSHION		Manufactured	No				Each	98.0000		4	Ag	12-1-30	

Location

Loc Qty

Loc Code

MAT052

98

70975

21

74300

77

MS21920-20

Clamp (per MIL-DTL-8783C)

Purchased

No

Each

60.0000

4

Ag 12-1-30

Location

Loc Qty

Loc Code

LG050

60

116799

10

119386

50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Item	Qty -241	Part Number	Description
1	X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
2	1	D6003-102	CROSSTUBE
3	2	D2891-1	SUPPORT
4	4	D3595-063-395	RUBBER CUSHION
5	4	MS21920-20	CLAMP (OR MS21920-21)
6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60 ± 0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 22.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS MECHANISMS ARE LOCATED ON CROSSTUBE CLAMPS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

UNDER REVIEW

RELEASED
06/11/12

DEO ATTACHED

C	REFORMAT/REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C5-3, C4-3, D3-3); RELOCATED FLAG #6 (ZN A7-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-241	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OFFER OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

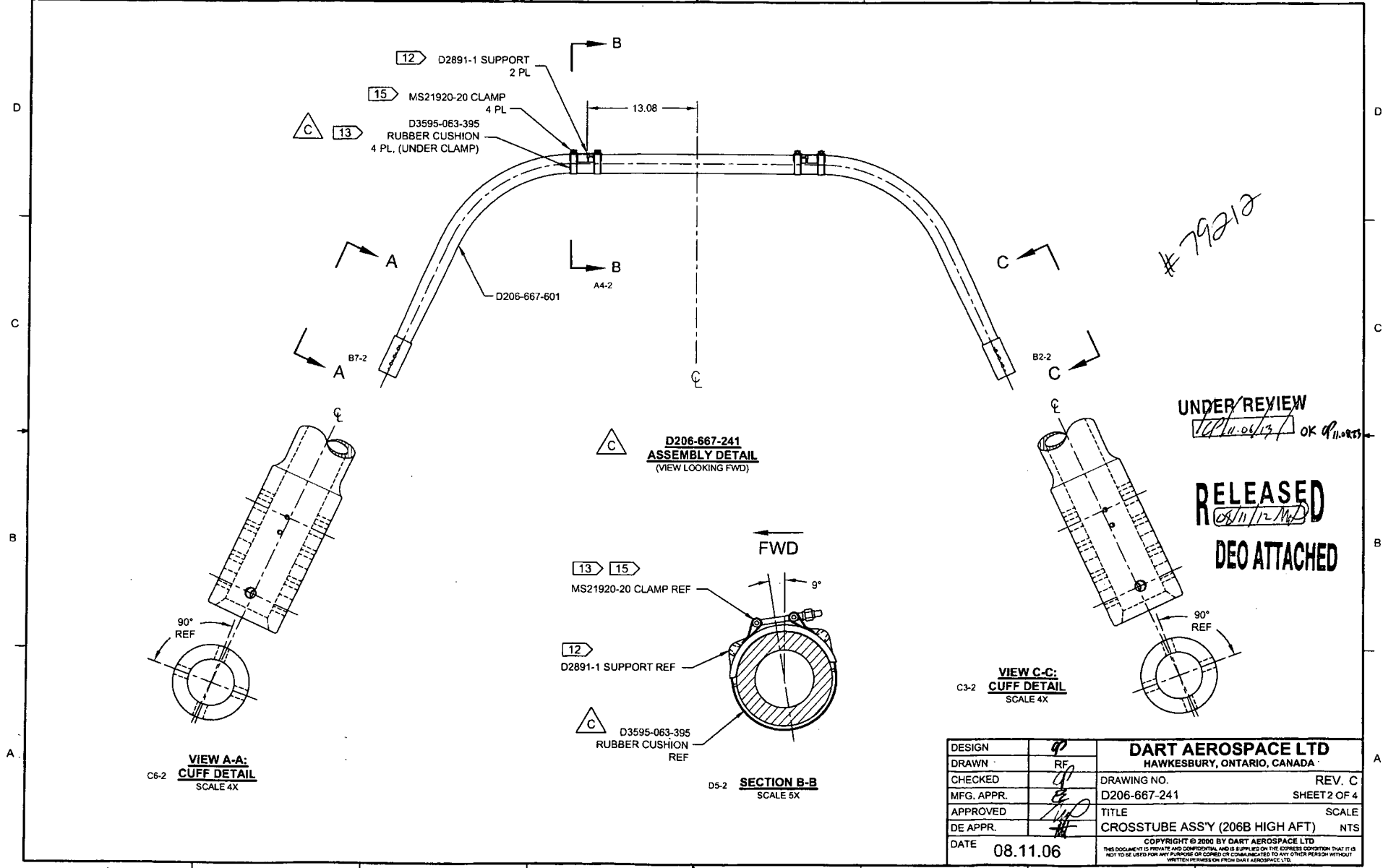
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



#79212

UNDER REVIEW
08.11.06/13 OK of 11.08.05

RELEASED
08.11.12
DEO ATTACHED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-241	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

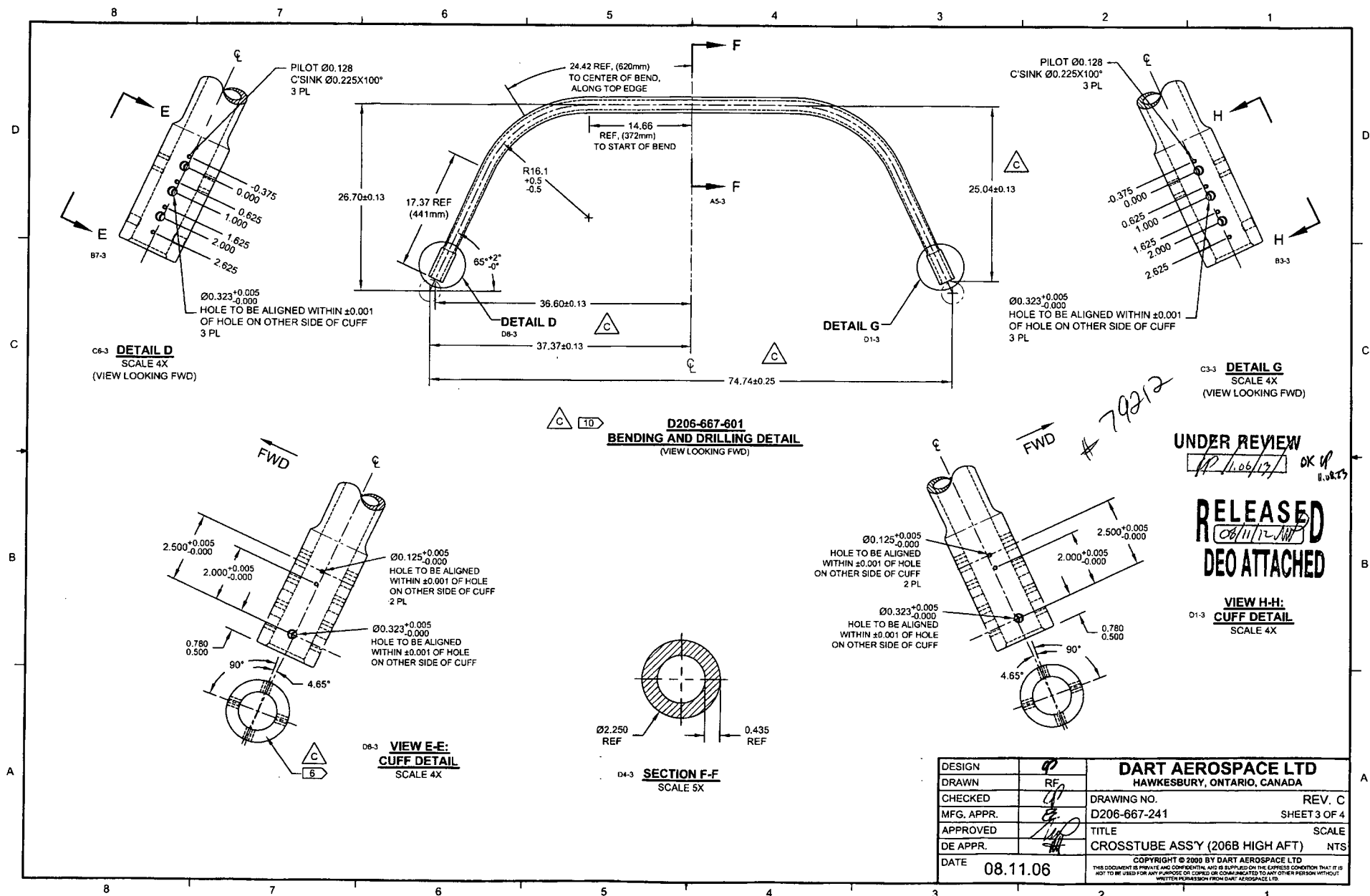
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

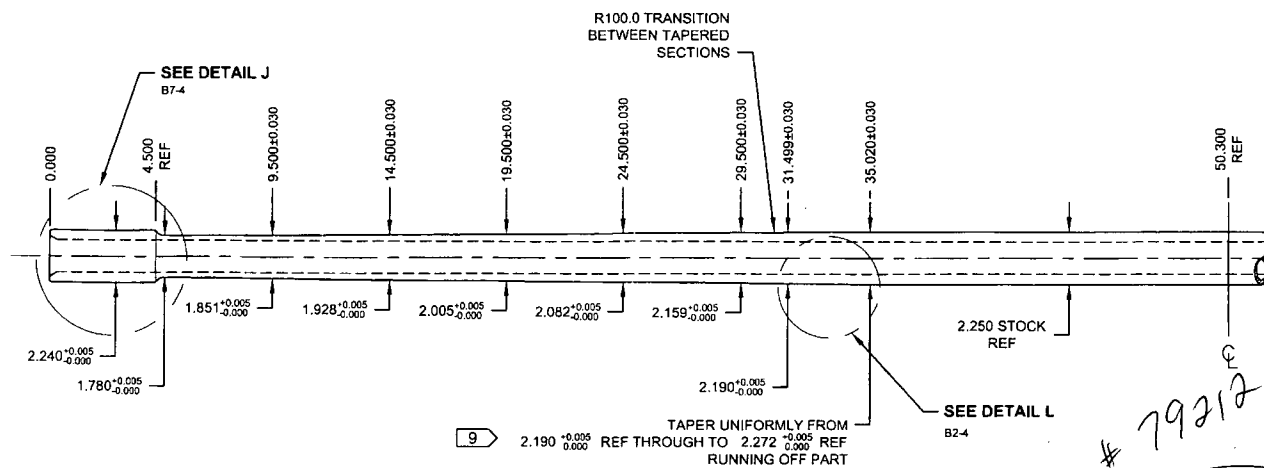
A

D

C

B

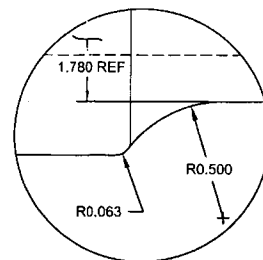
A



9

C

TURNING DETAIL

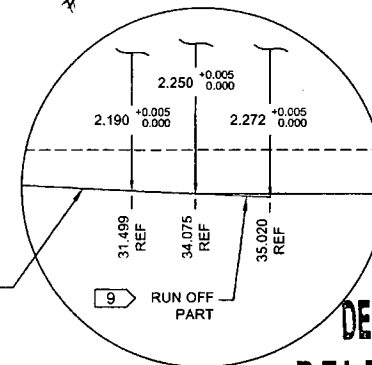


A6-4

DETAIL K:
CUFF TRANSITION
NOT TO SCALE

SEE DETAIL L
B2-4

R100.0 REF



DETAIL L:
TAPER RUN-OFF
NOT TO SCALE

UNDER REVIEW

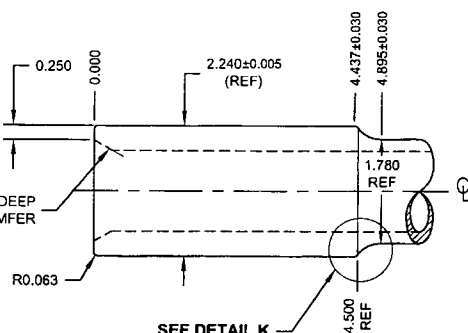
08/11/12

DEO ATTACHED

RELEASED

9

30° X 0.500 DEEP
CHAMFER



SEE DETAIL K
B4-4

DETAIL J:
CROSSTUBE CUFF
NOT TO SCALE

D7-4

DESIGN	0	DART AEROSPACE LTD
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA
CHECKED	0	DRAWING NO. REV. C
MFG. APPR.	0	D206-667-241 SHEET 4 OF 4
APPROVED	0	TITLE SCALE
DE APPR.	0	CROSSTUBE ASSY (206B HIGH AFT) NTS
DATE	08.11.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD
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8 7 6 5 4 3 2 1

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DRAWING NO. D206-667-241	TITLE CROSSTUBE ASS'Y (206B HIGH AFT)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-241-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>92</i>	CHECKED <i>AS</i>	MFG. APPR. <i>M</i>	APPROVED <i>M</i>		DE APPR. <i>M</i>		
DATE 11.07.15	DATE 11.08.22	DATE 11.08.22	DATE 11/08/22		DATE 11.08.22		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -241	Part Number	Description
6	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRAD MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

79212

RELEASED
2011-08-23
M

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C OR EARLIER REVISION
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2 OR EARLIER REVISION

REF TCCA STC: SH01-5

REF FAA STC: SR01304NY

REF EASA STC EASA.IM.R.S.01179

PURPOSE:

For the D206-667-201 Crosstube Installation, the parts list was missing the required drill bit specified in Figure 5 of IIN-D206-667 and Figure 32-5 of ICA-D206-667.

CHANGE:

For the D206-667-201 Crosstube Installation, the included D3039-3 Center Drill is used to open the specified holes to $\varnothing 0.313$ ". The hole must then be opened to $\varnothing 0.323$ " $\pm 0.005/-0.000$. The parts list of IIN-D206-667 and ICA-D206-667 is amended as follows:

5.0 PARTS LIST (IIN-D206-667 REV. C OR EARLIER REVISION)

32.8 PARTS LIST (ICA-D206-667 REV. 2 OR EARLIER REVISION)

QTY	PART NUMBER	DESCRIPTION
-201		
X	D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
1	D3039-3	CENTER DRILL (ADD)

79212

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.07.06
CERT. NO.: SH01-5
ISSUE NO.: 3

A	NEW ISSUE, NCR 09-005	CP	09.07.06
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	5	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9471	SHEET 1 OF 1
APPROVED	WAF	TITLE	SCALE
DE APPR.	TH	CENTER DRILL ADDITION	NTS
DATE	09.07.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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